

**Work Order ID 65807**

Wednesday, January 26, 2011 10:54:54 AM

Page 1

Item ID: D350-589-011

Accept

Revision ID:

Item Name: Side Door Latch Modification

Start Date: 1/26/2011 Start Qty: 4.00

Required Date: 2/7/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

INN-D350-589

E

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type label as per PPP D350-589-011 CHG002

0.00

Sulorly

JG BG 11-02-11

105

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

11/2/11 (48) SP

110

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

Sulorly

(48)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65807**

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Page 2

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Start Date: 1/26/2011 Start Qty: 4.00

Required Date: 2/7/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per QSI 014								
130  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

Loc 22  
REUF

11/2/11

(40)

11/02/14

MF

11-02-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, January 26, 2011 10:55:00 AM

Page 1

Work Order ID: 65807

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F02.08.29 Removed D2587 Plug KJ  
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10 NAS1149D0363J Purchased No



Washer

105 Each 8.0000

3 12



11/2/11

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

D2237



Striker Plate

Manufactured No

105 Each 62.0000

3 12



11/2/11

Location

Loc Qty

Loc Code

ST009

62

64426

22

64762

40

D2583



Latch Bracket

Manufactured No

105 Each 24.0000

3 12



11/2/11 (4)

Location

Loc Qty

Loc Code

ST017

23

64775

23

ST018

1

56527

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Side Door Latch Modification

Start Date: 1/26/2011

Required Date: 2/7/2011


Start Qty: 4.00

Required Qty: 4.00

D2585  


Manufactured No 105 Each 44.0000

Mounting Channel

3 12  
 11/2/11 SP

Location Loc Qty Loc Code

ST 3

64655 3


ST017 41

64761 41

D2586  


Manufactured No 105 Each 60.0000

Door Latch

3 12  
 11/2/11 SP

Location Loc Qty Loc Code


ST204 60

64656 60

D2587  


Manufactured No 105 Each 20.0000

Door Slug, 350 Hinge

1 4  
 11/2/11 SP

Location Loc Qty Loc Code

ST018 20

64314 20

D2589  


Manufactured No 105 Each 111.0000

Keys, Key Chain, 350 Hinge

1 4  
 11/2/11 SP

Location Loc Qty Loc Code

ST019 111

58194 111

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-5;

Purchased

No

105

Each

1,262.000

6



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1262

116410

1262

105

Each

3,059.000

3

MS21042L3

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

3059

114784

9

115835

550

116391

900

116540

800

116549

800

MS27039-1-15

Purchased

No

105

Each

51.0000

3



Screw

Location

Loc Qty

Loc Code

ST292

51

114718

1

116169

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## 52.4 PARTS LIST

## REFERENCE

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

\* Reference only. Included in D3085-041 Prop Assembly listed above.

\*\* Reference only. Included in D2991-1/-2/-3 Doors listed above.

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